

Push

Work Order ID 63244

Tuesday, October 26, 2010 10:16:52 AM



Page 1

Item ID: D3201-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 10/26/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: 10/10/26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3201

Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3201
Deburr if necessary

☐ Dwg Rev: *B*

☐ Prog Rev: *B*

☐ 2-

B10-10-26

(20)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-10-26

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 10/10/26

counted
(422)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Process Plan:

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Debur Stack

0.00

0.00

W/AD

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

10/10/26

22

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

10/10/26

22

Ø

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Page 3

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Accept

Revision ID:

Item Name: Doubler

Start Date: 10/26/2010 Start Qty: 20.00

Required Date: 10/29/2010 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 40

0.00



Packaging

Memo

0.00

Packaging

10/10/27
10/10/27

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/27
NF
10-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Tuesday, October 26, 2010 10:16:56 AM

Page 1

Work Order ID: 63244

Parent Item: D3201-1

Parent Item Name: Doubler



Start Date: 10/26/2010

Required Date: 10/29/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-25 JLM
IPP Rev:B Now on Waterjet 06-08-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

100

sf

321.7400

0.276

5.810526

6.1



1310-10-26

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT

84.2

114415

84.2

114415

MAT22

237.54

110305

21.93

111786

13.76

112291

28.25

112331

52

113162

121.6

27

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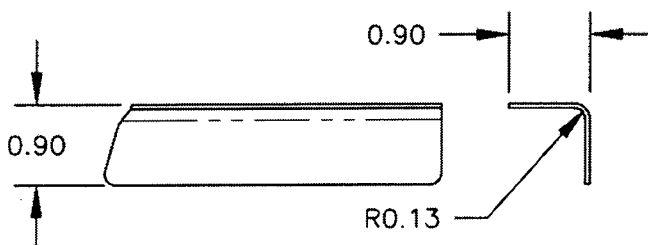
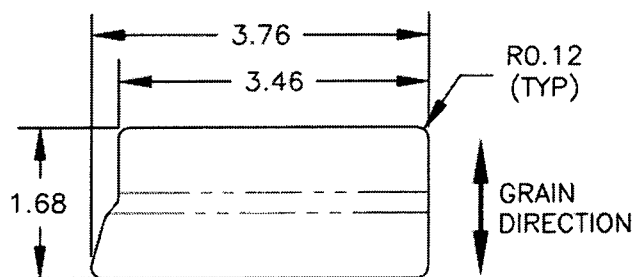
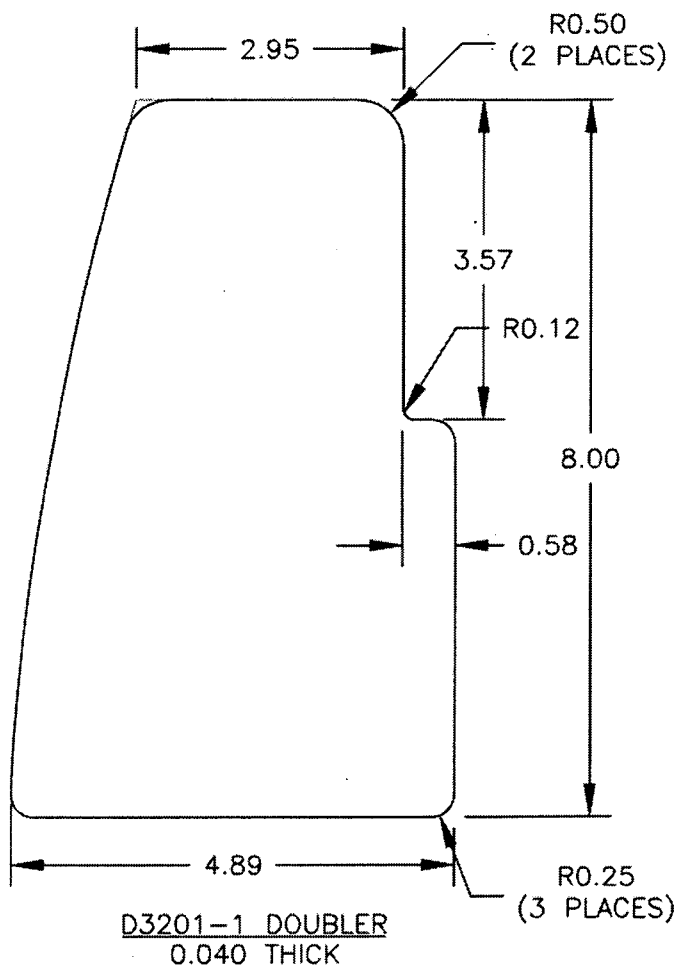
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3201	REV. B SHEET 1 OF 1
DATE 03.11.03	TITLE DOUBLER		SCALE 1:2
A	03.08.07	NEW ISSUE	
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4	

RELEASED
03.11.14



D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63244

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